

# Work Order ID 85838

June-15-12 1:35:31 PM

**\*85838\***

Page 1

Item ID: D4151-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Upper Hardpoint Plate

Start Date: 15/06/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/15 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C					(12)			
100		0.00							
<b>*100*</b>									
Waterjet		0.00							
FLOW CNC Waterjet									
304, 105									
	Memo								
	Cut as per dwg D4151								
	Prog Rev: <u>E</u>								
	Dwg Rev: <u>E</u>								
	Deburr as required								
110		0.00							
<b>*110*</b>									
QC		0.00							
Quality Control									
	Memo								

12-6-18

12-6-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*85838\***

Page 2

Item ID: D4151-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Upper Hardpoint Plate

Stop **\*NS2\***

Start Date: 15/06/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

8/16/12

16

Quality Control

150

Identify as per dwg & Stock Location **103**

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

100

12/6/12

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/6/12

MF 12-06-12

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:35:35 PM

Page 1

Work Order ID: 85838

\*85838\*

Parent Item: D4151-3

\*D4151-3\*

Parent Item Name: Upper Hardpoint Plate

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	96.0760	0.055	0.694737	16	1.	

\*M304S11GA\*

304/316 0.125 Sheet

\*\*

Biz-6-18

## Location

## Loc Qty

## Loc Code

MAT020

96.076

121380

24.9

121780

71.176

121780

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

**D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)**

**D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 85838 MLJ

12/06/15 RELEASED

2011-01-28

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2); 2.84 WAS 2.78 (D3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1 SED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-M20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C  
SHEET 1 OF 3  
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT:  
- D4151-041 = 0.88 lbs  
- D4151-043 = 1.17 lbs

# Dart Aerospace Ltd

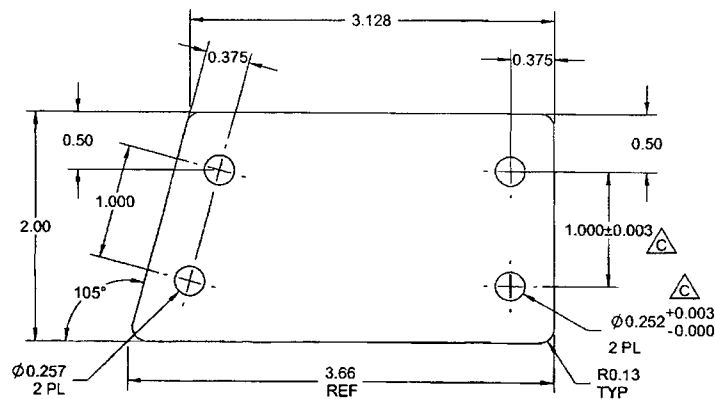
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

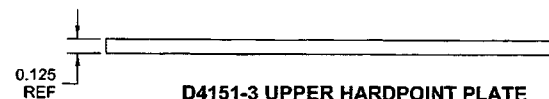
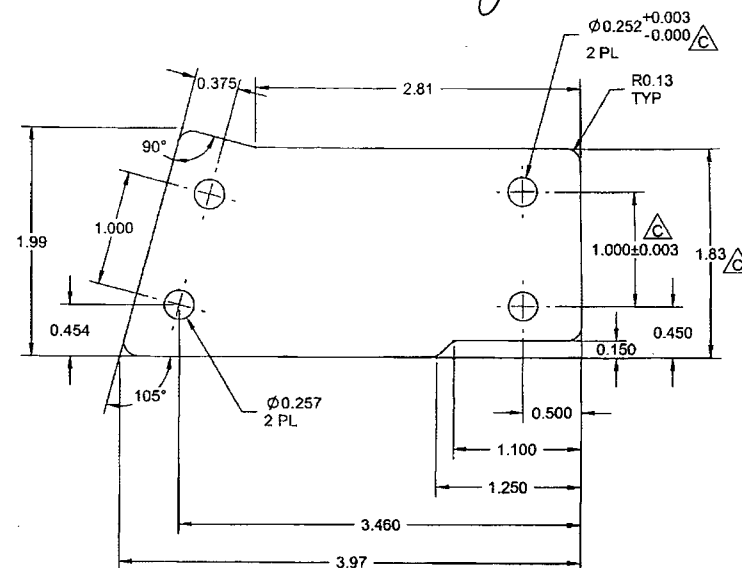
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**NOTE:** Date & initial all entries




**D4151-1 LOWER HARDPOINT PLATE**



**D4151-3 UPPER HARDPOINT PLATE**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:  
- D4151-1 = 0.24 lbs  
- D4151-3 = 0.23 lbs

DESIGN			<b>DART AEROSPACE LTD</b>	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			<b>D4151</b>	SHEET 2 OF 3
APPROVED			TITLE	SCALE
DE APPR.			<b>BASKET FWD HARDPOINT</b>	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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2011-01-18  
JMD

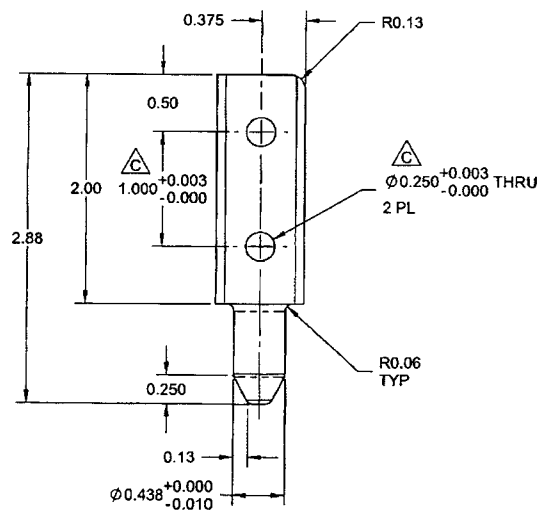
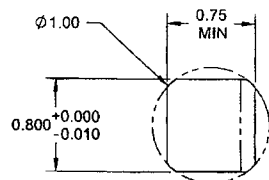
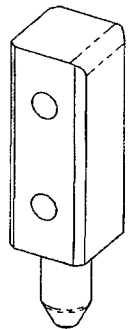
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

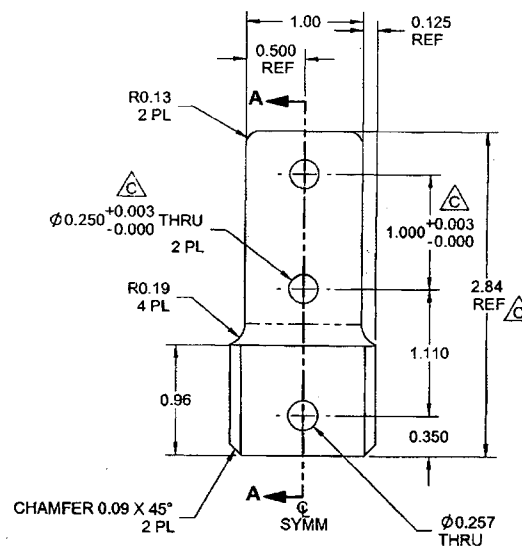
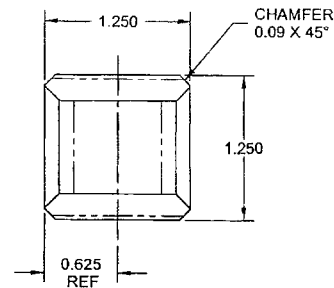
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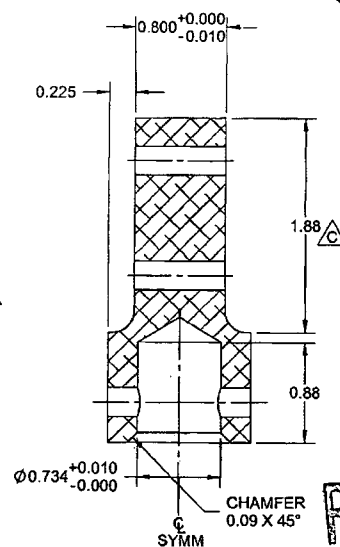
**NOTE:** Date & initial all entries



**D4151-5 FWD BASKET INSTL STUD (LOWER)**



**D4151-7 FWD EYEBOLT RECEIVER (UPPER)**



**SECTION A-A**

- NOTES:**
- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R  
-7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
  - 7) WEIGHT -5: 0.36 lbs  
-7: 0.70 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4151</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET FWD HARDPOINT</b>	NTS
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2011-09-30  
**RELEASED**

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